parweld
WELDING THE FUTURE

Test Certificate: **104469**

To:
PARWELD LIMITED
BEWDLEY BUSINESS PARK
LONG BANK
BEWDLEY
WORCS
DY12 2TZ

Date: 12/07/2019

Order No: 21845

Advice Note No: 53547

Material:
A32
2.4mm
TIG x 5KG

Quantity, KG:
10

Cast No:	492030

Specification:
AWS A5.28/A5.28M: ER80S-G
BS EN ISO 21952-A: W CrMo1Si

Chemical Analysis EN 10204: 3.1

C	Si	Mn	P	S	Cr	Ni	Mo	Fe	Cu *
0.08	0.57	0.98	0.006	0.011	1.18	0.04	0.50	Bal	0.037

W	Nb	Al	V	Ti	Co	Pb	Sn	B	As
	0.002	0.002	0.006	0.002	0.0010	0.001	0.004	0.0010	0.001

Zr	Ta	Sb	N	Bi	Zn	Mg	Be	Ce	Ca
0.001	0.001	0.0010							

Ag	Ga	Y				X Factor	FN-WRC	OE **	TOE **
									<0.50

* Copper excluding copper coating. ** Other elements individual. *** Other elements total.

Mechanical properties of pure weld metal EN ISO 15792-1 test report EN 10204: 2.2

	PWHT	**Rp0.2 %**		**Rm**		**A5**		**Av**	
TYPE		Min	Result	Min	Result	Min	Result	Min	Result
	°C/hr	MPa	MPa	MPa	MPa	%	%	J @ °C	J @ °C
TIG	PWHT	≥ 355	442	≥ 510	545	≥ 20	28	≥ 47 @ -10	177 @ -10

Certified that the product(s) detailed hereon have been inspected and tested in accordance with the conditions and requirements of the purchase order and unless otherwise noted conform in all respects to the specifications relevant thereto.

Signed: